



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
Order 5782

003475

648.4704

Job Sheet 176746



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled *At Planning*

Priority: Medium

Job Created: 4/30/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Small Fab-3		<i>JB</i>
100	Small Fab	1 pcs	5/24/18	5/24/18	0.00	1.00	Small Fab-3		<i>18-06-05 JB</i>
120	QC	1 pcs	5/24/18	5/24/18	0.00	0.00	QC4		<i>38</i>
121	DC	1 pcs	5/24/18	5/24/18	0.00	0.00	DC		<i>SRB 9-85 JAS 28</i>
130	Packaging	1 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		<i>28</i>
140	QC21-FG	1 Ea	5/24/18	5/24/18	0.00	0.00	QC21		<i>DAG 7-89</i>

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer -	3 Ea (3 ea)	90-Start up Operation	<i>5056461</i>
NAS1149F0563P	Washer -	8 Ea (8 ea)	90-Start up Operation	<i>5054114</i>
188-FPSS-1/4-20-3/8	Set Screw -	2 Ea (2 ea)	100-Small Fab	<i>5048557</i>
188-FSCS-1032-5/8	Screw -	4 Ea (4 ea)	100-Small Fab	<i>5062757</i>
600.1309-A <i>P</i>	Label -	1 Ea (1 ea)	100-Small Fab	<i>5064516</i>
600.1312	Caution Sticker -	1 pcs (1 ea)	100-Small Fab	<i>5072105</i>
AN4-23A	Bolt -	2 Ea (2 ea)	100-Small Fab	<i>F123439-40</i>
AN5-21A	Bolt -	4 Ea (4 ea)	100-Small Fab	<i>5057451</i>
C2-14-2	Label Rivets -	2 Ea (2 ea)	100-Small Fab	<i>5057170</i>
C45-10-1	Spring Pin -	1 Ea (1 ea)	100-Small Fab	<i>5040658</i>
C45-10-2	Lock Spring -	1 Ea (1 ea)	100-Small Fab	<i>5048643</i>
C45-11-2 <i>P</i>	Locating Pin -	2 Ea (2 ea)	100-Small Fab	<i>5029297</i>
C45-12-1	Lock Bushing -	2 Ea (2 ea)	100-Small Fab	<i>5060715</i>
C45-12-6 <i>P</i>	Retaining Ring -	2 Ea (2 ea)	100-Small Fab	<i>5029363</i>
C45-13-1	Keeper Bushing -	2 Ea (2 ea)	100-Small Fab	<i>5069580</i>
C45-13-2 <i>P</i>	Spacer -	2 Ea (2 ea)	100-Small Fab	<i>5029365</i>
C45-13-5 <i>P</i>	Keeper Spring -	1 Ea (1 ea)	100-Small Fab	<i>5029308</i>
C45-3-1	Radial Bearing -	2 Ea (2 ea)	100-Small Fab	<i>5052562</i>
C45-3-12 <i>P</i>	DU Bearing -	1 Ea (1 ea)	100-Small Fab	<i>5053842</i>
C45-3-2-1 <i>P</i>	Snap Ring -	2 Ea (2 ea)	100-Small Fab	<i>5029317</i>
C45-3-4-1 <i>P</i>	Retaining Ring -	4 Ea (4 ea)	100-Small Fab	<i>5029320</i>
C45-3-5 <i>P</i>	Spacer -	2 Ea (2 ea)	100-Small Fab	<i>5029321</i>
C45-3-8A	Actuator Shaft Bushing -	1 Ea (1 ea)	100-Small Fab	<i>5074268</i>

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																															
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S075188 Part: 648.4704 Job No: 176746 Serial No/Batch: S075188 Revision: 4 Inspector: Date: 05/29/18				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																													
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2"></th> <th colspan="2"></th> <th colspan="2"></th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-vo</td><td>☐</td> <td></td><td></td> <td>is/Surge</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operato</td><td>☐</td> <td></td><td></td> <td>gram</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/!</td><td>☐</td> <td></td><td></td> <td></td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> <td></td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/wave</td><td>☐</td> <td>tock Pulled</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>equence</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Off-set</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Mislabeled</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Fit/Function</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="4" rowspan="2"></td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> <tr> <td colspan="4"></td> <td colspan="4" style="text-align: center;">OTHER : _____</td> </tr> </tbody> </table>						Root Cause								Environment	☐	No Re-vo	☐			is/Surge	☐	Design	☐	Operato	☐			gram	☐	Doc/Data	☐	Offset/!	☐				☐	Equip/Tooling	☐	Supplier	☐				☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/wave	☐	tock Pulled	☐	Material	☐	Use for Testing	☐	Cuffs	☐	equence	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Past Expiry Date	☐	Manufacturing Process	☐					Misidentified	☐	Past Due	☐					OTHER : _____			
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C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5074266
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab	5029325
C45-4-1	Turnion Bushing	2 Ea (2 ea)	100-Small Fab	5074149
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab	5029329
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab	5029332
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab	5075337
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab	5029336
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab	5057526
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab	5039330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	472	0
	NAS1149F0563P	8	161	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	46	0
	188-FSCS-1032-5/8	4	257	0
	600.1309-A	1	0	0
	600.1312	1	0	0
	AN4-23A	2	600	0
	AN5-21A	4	53	0
	C2-14-2	2	264	0
	C45-10-1	1	94	0
	C45-10-2	1	16	0
	C45-11-2	2	42	0
	C45-12-1	2	22	0
	C45-12-6	2	48	0
	C45-13-1	2	0	0
	C45-13-2	2	86	0
	C45-13-5	1	95	0
	C45-3-1	2	26	0
	C45-3-12	1	17	0
	C45-3-2-1	2	58	0
	C45-3-4-1	4	64	0
	C45-3-5	2	80	0
	C45-3-8A	1	0	0
	C45-3-8B	1	0	0
	C45-3-9	1	0	0
	C45-4-1	2	2	0
	C45-5-1	1	16	0
	C45-7-1	1	0	0
	C45-7-2	2	2	0
	C45-8-4	1	11	0
	MS21044N5	4	99	0
	MS27039-4-08	1	86	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					